

**Work Order ID 80943**

Monday, March 05, 2012 4:56:00 PM

**\*80943\***Ship March 19th  
Page 1

Item ID: D4017-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Short Basket Base Assembly (350 )

Start Date: 3/5/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/15/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *UMF*Date: *12-03-06* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: *4115778* 0.00**\*100\***

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4017 using DT9610B  
\*\*\*inspect before welding mesh\*\*\*  
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary  
and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D4017  
\*\*\*take lid to locate hinge and bracket\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Memo

0.00

Quality Control

*SW 12-03-13 1x**Rpl 12-03-15 1x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 3/15/2012 Req'd Qty: 1.00

Reference:

Accept

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

Sickles

1 ID-3-5.

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 8h25OVEN TEMPERATURE: 400°FFINISH TIME: 8h55

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

IX Ø M / 12/03/17

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: *G-A*

0.00

**\*170\***

Packaging

Memo *a/o*

0.00

Packaging *80942**SP12/03/19 (1)**M 12-03-19 (1)**SP12/03/19 (1)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MCS 12/03/19

ME  
12-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Page 1

Work Order ID: 80943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4017-1 Rib		Manufactured	No			10G	Each	0.0000	1	1		B 80945 → 1x 12.03.12	
✓ D4018-1 Rib		Manufactured	No				Each	8.0000		1		12.03.12	
***D4018-1 is the same as D4017-3***				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA005		8							
				72545		5							
				76381		3							
✓ D4017-5 Hinge Rib		Manufactured	No			100	Each	1.0000	1	1		12.03.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA005		1							
				72558		1							
✓ D4017-7 Rib		Manufactured	No			100	Each	4.0000	1	1		12.03.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA005		4							
				69730		1							
				74682		3							
✓ D4017-9 Rib		Manufactured	No			100	Each	10.0000	2	2		12.03.12	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		4							
				79415		4							
				WA006		6							
				70341		2							
				73531		4							

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 80943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D3916-041  
Rib Assembly

Manufactured No

100 Each 4.0000 2

Location

Loc Qty

Loc Code

WA006

4

69161

2

78494

2

2x 12.03.12

✓ D3916-5  
Light Rib

Manufactured No

100 Each 12.0000 1

Location

Loc Qty

Loc Code

WA

3

75305

3

WA006

9

79908

9

2x 12.03.12

✓ D4034-041  
Aft Upper Rib Assembly

Manufactured No

100 Each 1.0000 1

Location

Loc Qty

Loc Code

WA006

1

78038

1

1x 12.03.12

✓ D4034-043  
Fwd Upper Rib Assembly

Manufactured No

100 Each 1.0000 1

Location

Loc Qty

Loc Code

WA006

1

78036

1

1x 12.03.12  
B 78 329 → 1x 12.03.12

✓ D2581  
Mounting Bracket

Manufactured No

100 Each 43.0000 2

Location

Loc Qty

Loc Code

WA005

43

69739

1

70766

2

77045

11

77523

29

2x 12.03.12

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 80943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

D3913-15  
Wide Handle Plate

Manufactured No

100 Each 3.0000

1

Location

Loc Qty

Loc Code

WA005

3

74640

1

78321

2

D4016-1  
Hinge Half, Base

Manufactured No

100 Each 29.0000

3

3

Location

Loc Qty

Loc Code

WA005

29

75281

10

79413

19

D4020-3  
Mesh (350 Basket Short, Base)

Manufactured No

100 Each 0.0000

1

1

D4020-11  
End Mesh, Basket

Manufactured No

100 Each 12.0000

2

2

Location

Loc Qty

Loc Code

WA035

12

69648

2

78693

10

D2931  
Bumper

Manufactured No

150 Each 502.0000

2

2

Location

Loc Qty

Loc Code

ST504

502

46064

502

12.03.12

1x

12.03.12

3x

B 8/321 → 1x 12.03.13

12.03.13

2x

12/03/19

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 80943

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350 )

Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-1 1 6 Manufactured No

100 Each 14.0000

3

W 3 12.03.13

Handle Plate

Location	Loc Qty	Loc Code
WA	11	
69518	0	
74316	0	
74946	0	
79414	11	
WA005	3	
74986	3	

W 3x

D4021-5 Manufactured No

150 Each 10.0000

2

2

EP 12/03/19

Blanking Plate

Location	Loc Qty	Loc Code
GA	10	
73478	10	

2

AN3-10A Purchased No

150 Each 388.0000

6

6

EP 12/03/19

Bolt

Location	Loc Qty	Loc Code
GA	84	
119084	84	
ST351	304	
117795	4	
120873	300	

6

AN960JD8 NAS1149DN832J Purchased No

150 Each 0.0000

2

2

EP 12/03/19

Washer

47 M119717 (2x)

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Page 4

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Start Date: 3/5/2012

Required Date: 3/15/2012

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

150

Each

1,316.0000

2

2

Cherry Rivets

Location

Loc Qty

Loc Code

ST321

1183

111636

36

117505

10

117601

35

118626

602

120308

500

WA018

133

107939

133

MS21042L3

Purchased

No

150

Each

3,681.0000

6

6

Nut

Location

Loc Qty

Loc Code

ST300

3681

117441

16

117885

32

118451

5

118927

3

119017

3428

119075

197

NAS1149F0332P

Purchased

No

150

Each

616.0000

12

12

WASHER

Location

Loc Qty

Loc Code

ST275

616

117735

37

119225

176

120498

200

120910

200

17317

3

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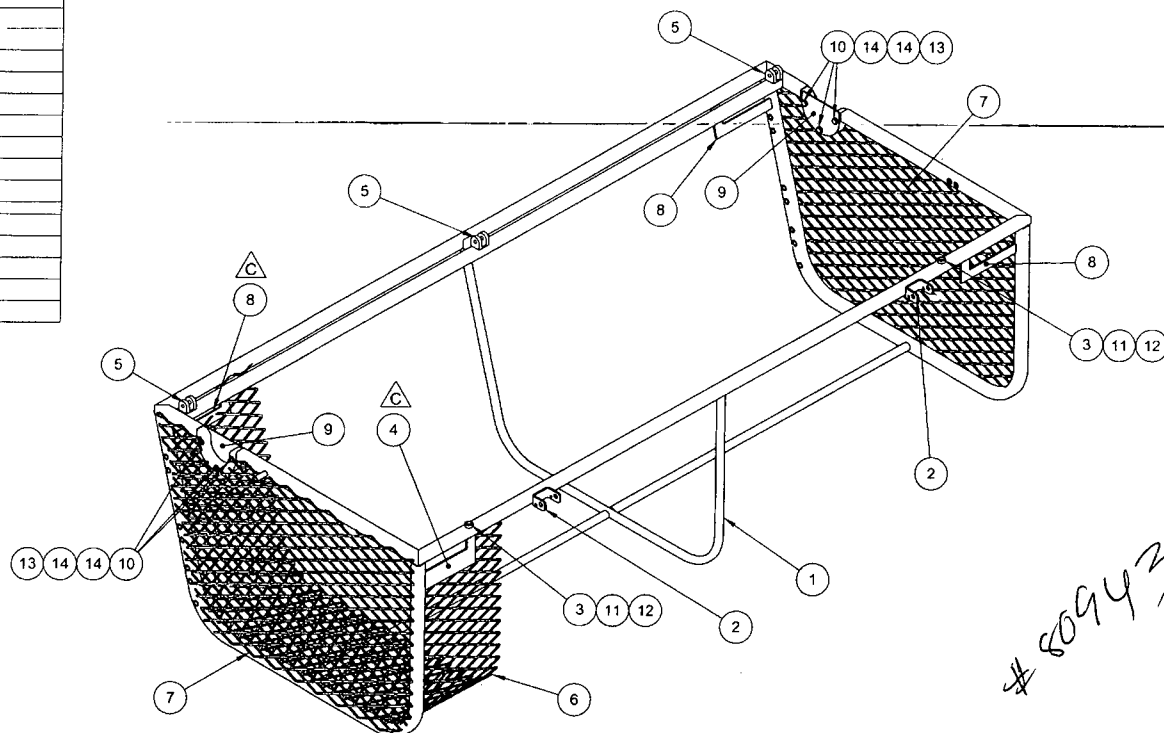
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ITEM	QTY	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D4017-041 SHORT BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596  
**RELEASED**  
10.08.12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A, NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4017</b> REV. C SHEET 1 OF 5 SCALE <b>SHORT BASKET BASE ASSY (350) _NTS</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN			
CHECKED			
MFG. APPR.	J.F.S.		
APPROVED			
DE APPR.		DATE <b>10.07.23</b>	

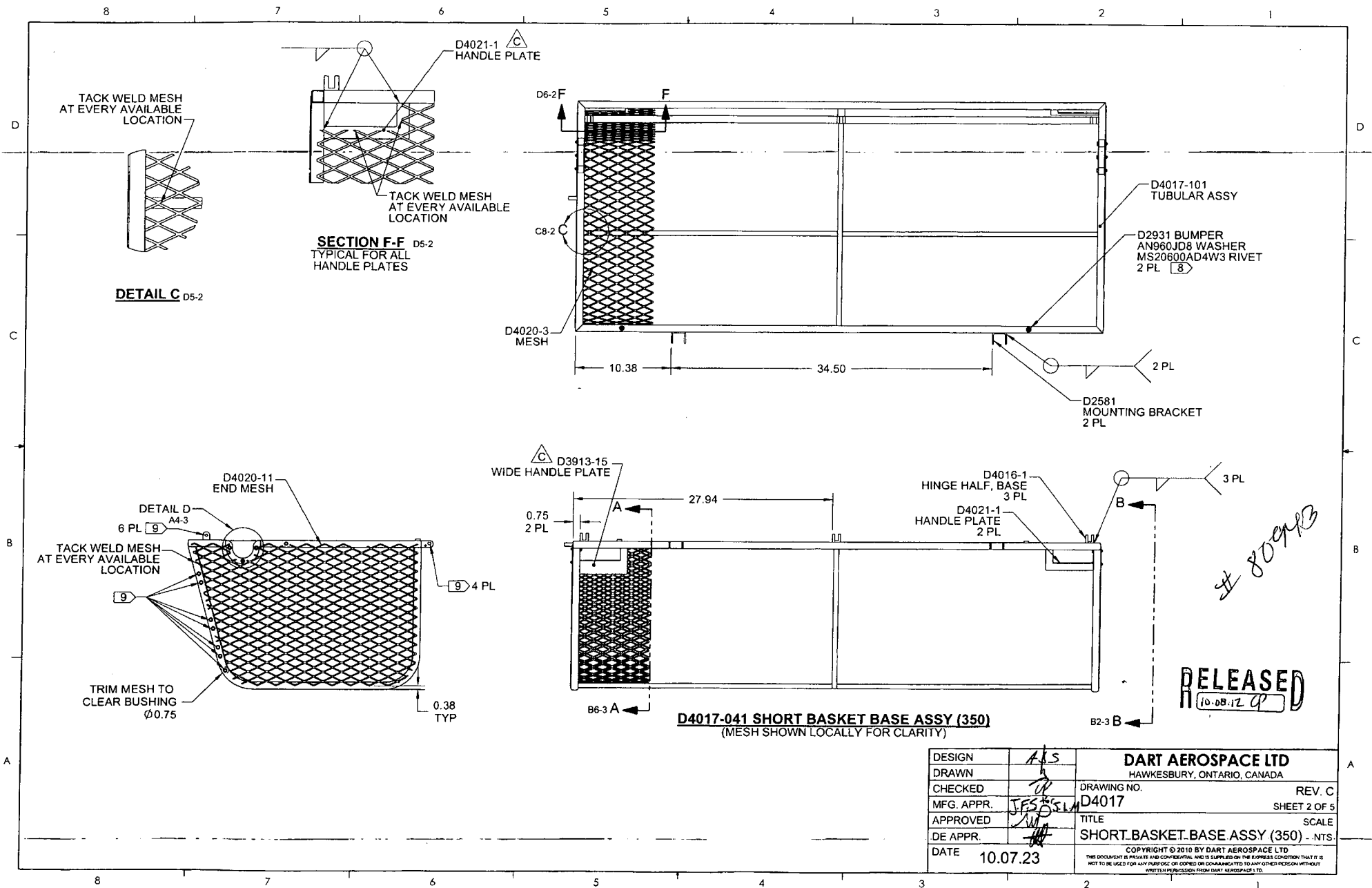
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

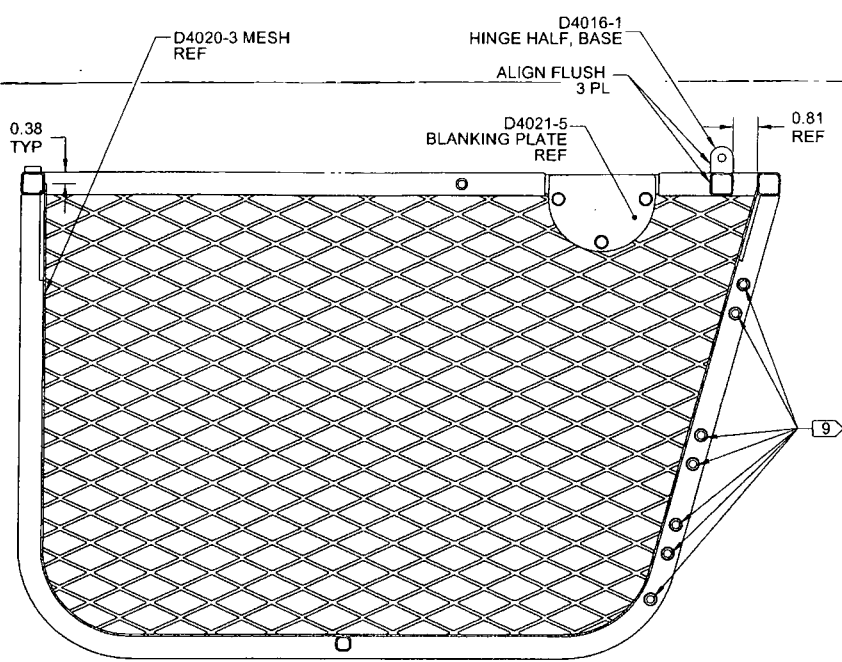
**NOTE:** Date & initial all entries



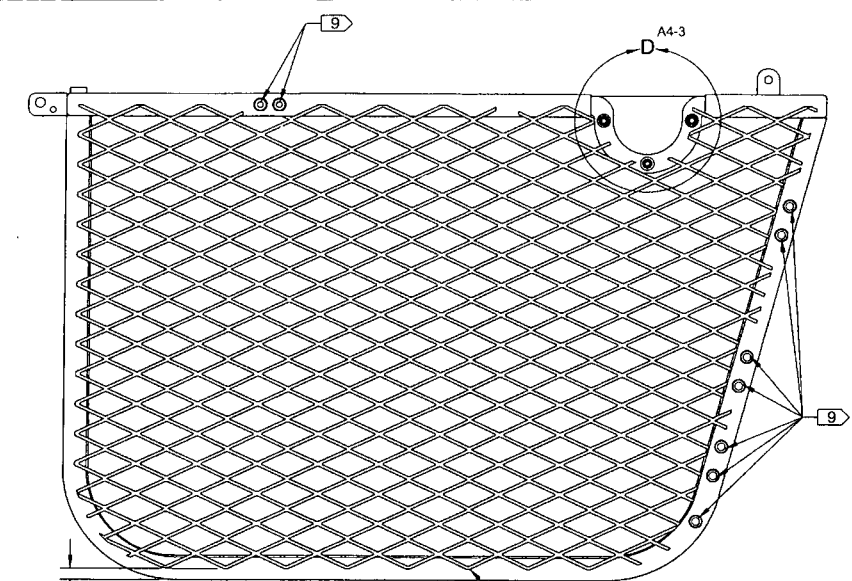
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D  
C  
B  
A

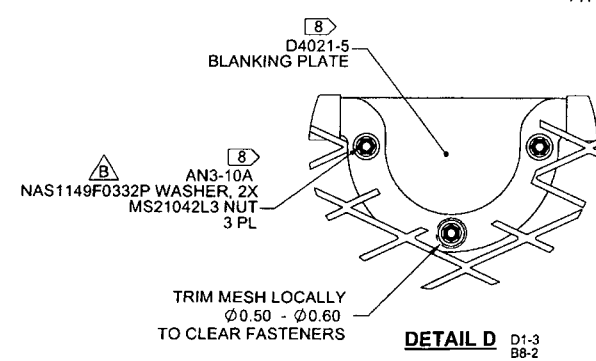
D  
C  
B  
A



**SECTION A-A** A5-2



**SECTION B-B** A2-2



**DETAIL D** D1-3 B8-2

# 80943

**RELEASED**  
10.08.12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO. <b>D4017</b>	REV. C
MFG. APPR.	JFS	TITLE	SHEET 3 OF 5
APPROVED	JM	<b>SHORT-BASKET-BASE ASSY (350)</b>	SCALE
DE APPR.			-NTS-
DATE	10.07.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

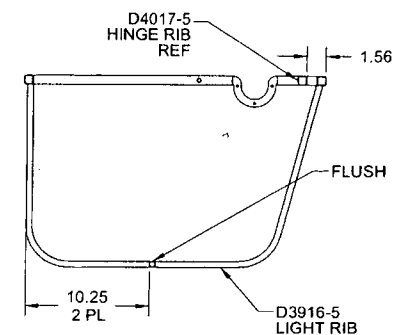
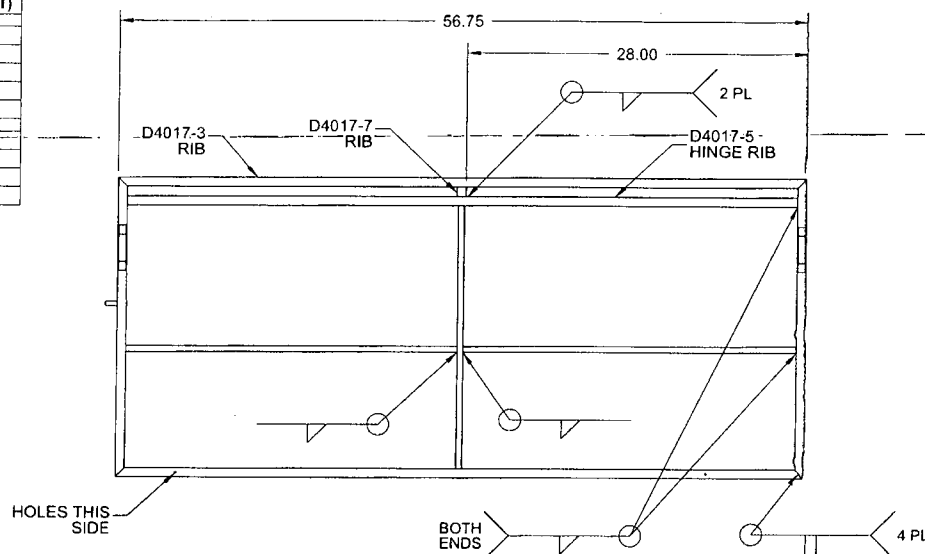
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

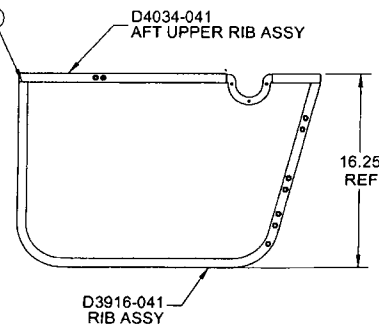
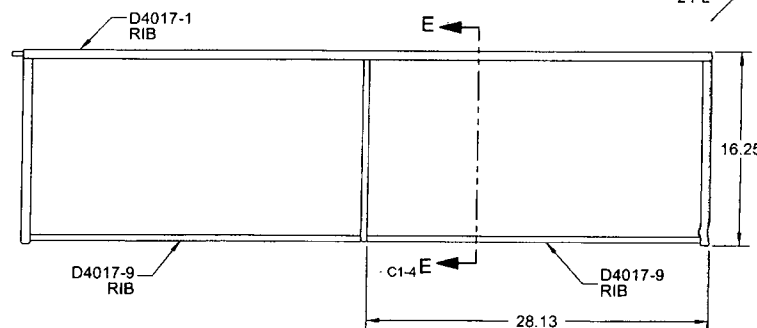
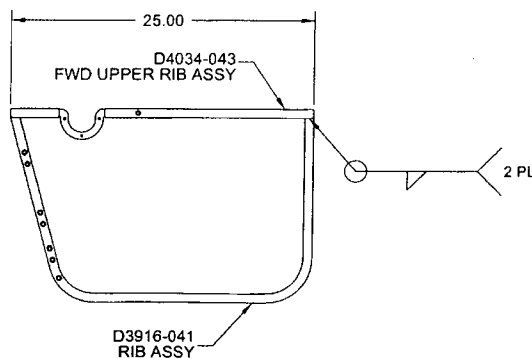
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



SECTION E-E A4-4



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 15.26 lbs
  - 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4017-101
  - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	ALS	DART AEROSPACE LTD	REV. C
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	STP	DRAWING NO. D4017	SHEET 4 OF 5
MFG. APPR.	STP	TITLE	SCALE
APPROVED	JP	SHORT BASKET-BASE ASSY (350) INTS	
DE APPR.	JP		
DATE	10.07.23		

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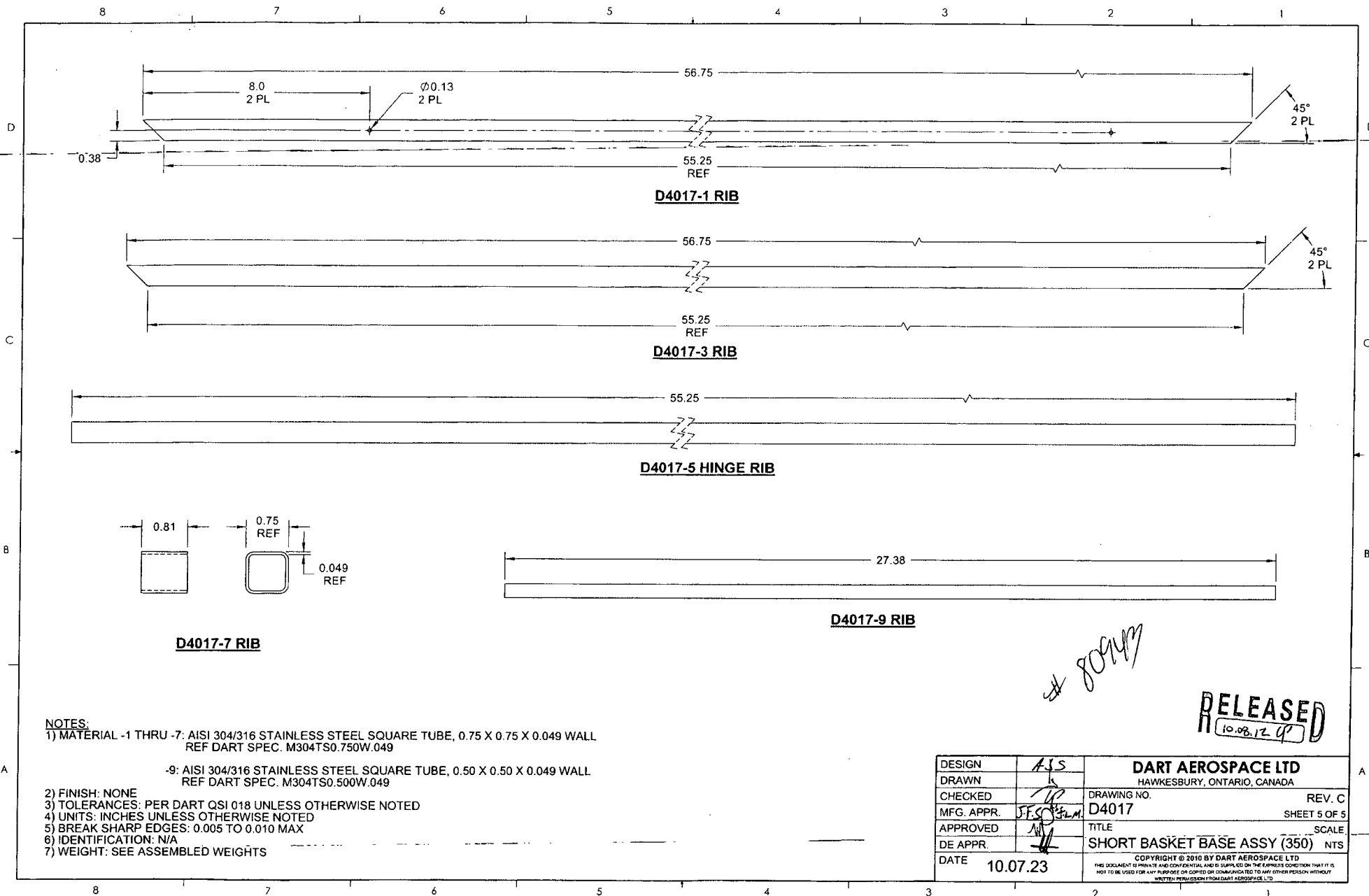
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